

Date: Monday, 3/19/2007 4:38:00 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 4" HEATER TUBE
Job Number	: 31297		
Estimate Number	: 12698		
P.O. Number	: <i>N/A</i>	Part Number	: D22913
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2291 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30599	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/30/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>07.03.20</i>		
Comment	: Est Rev: A New Issue 07-02-02 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6T4000W125	6061-T6 Tube 4.00 x.125W
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Comment: Qty.: 0.3500 f(s)/Unit Total : 1.3999 f(s)  
6061T6 TUBE 4.00 x .125w  
Batch: *B 2288*

*FF 07-05-03 4*

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Cut to length as per Dwg D2291

*FF 07-05-03 4*

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*SD 07/05/08 (4)*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*07/05/08 (4)*

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*07/05/08*

Job Completion



*07-05-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

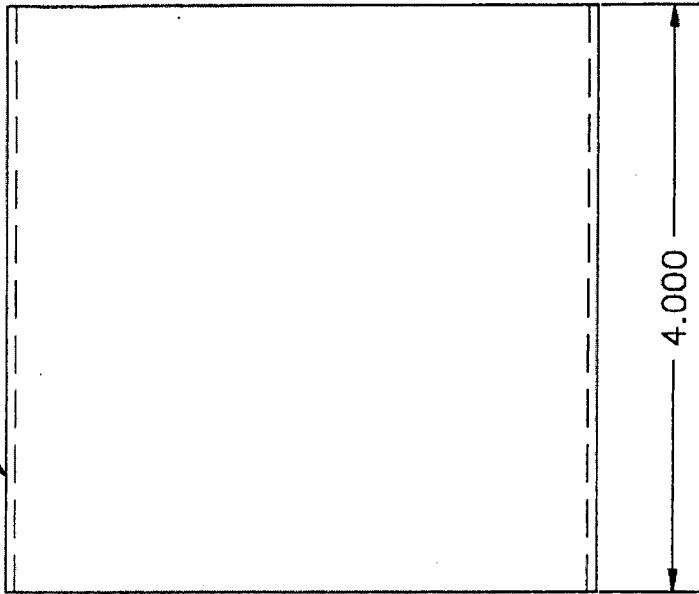
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/03	2	4" Heater tube was out of tolerance Too Short, cracked.	<i>[Signature]</i>	<del>Destroy &amp; Replace</del> <del>cut to 3"</del> SAUE material for A 02291-1 I.D. = stuck	FF 07/05/03	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

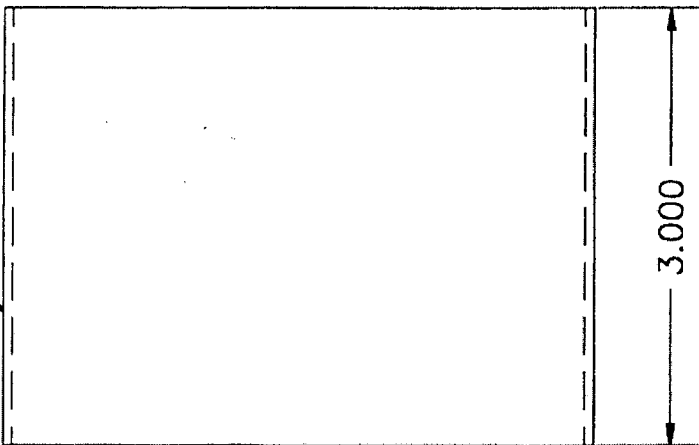


DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2291	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBES	
B	96.01.15	CHANGED MATERIAL	

D2291-3



D2291-1



MATERIAL: 6061-T6 TUBE  
4" OD X 0.125 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31297